

Work Order ID 67614

Monday, March 28, 2011 2:53:57 PM

Ship April 7



Page 1

Item ID: PB67-43001-63

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Assembly

Start Date: 3/28/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B67-43001-63

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps. to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg
- 9- assemble by drilling thru both -157 and -133 as per dwg
- 10- install spring slotted pin as per dwg

AL Rod Batch M114703

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

SE 11.04.05 3 4

3 0 SE 11/04/06

Work Order ID 67614

Monday, March 28, 2011 2:53:57 PM

Page 2

Item ID: PB67-43001-63

Accept

Revision ID:

Item Name: Handle Assembly

Start Date: 3/28/2011 Start Qty: 3.00

Required Date: 4/1/2011 Req'd Qty: 3.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: Date:

Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat****

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15
320°
8:45

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



3 11-4-7

3 8-11-07

Work Order ID 67614

Monday, March 28, 2011 2:53:57 PM



Page 3

Item ID: PB67-43001-63

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Assembly

Start Date: 3/28/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location

4/4

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/7 30

11/4/7 ME

11-04-07

Picklist Print

Monday, March 28, 2011 2:53:54 PM

Page 1
2

Work Order ID: 67614

Parent Item: PB67-43001-63

Parent Item Name: Handle Assembly

Start Date: 3/28/2011

Required Date: 4/1/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-07-29 new issue DD verified by:ec
10.09.30 per rev C dwg EC verified by:DD
IPP rev B

Component Item ID/ Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
----------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

67-43001-129		Manufactured	No			100	Each	3.0000	1	3			
													
be Handle													

Location	Loc Qty	Loc Code
ST447	3	

PB67-43001-127		Manufactured	No			100	Each	2.0000	1	3			
													
Handle Arm													

Location	Loc Qty	Loc Code
ST447	3	
45002	3	

Location	Loc Qty	Loc Code
ST446	2	
43327	2	

PB67-43001-157		Manufactured	No			100	Each	1.0000	1	3			
													
Tube													

Location	Loc Qty	Loc Code
ST446A	1	
43390	1	

PB67-43001-131		Manufactured	No			100	Each	10.0000	2	6			
													
Tube End Cap													

Location	Loc Qty	Loc Code
ST446A	10	
45770	10	

11.04.05

11.04.05

11.04.05

11.04.05

Picklist Print

Monday, March 28, 2011 2:53:54 PM

Page 2

Work Order ID: 67614

Parent Item: PB67-43001-63

Parent Item Name: Handle Assembly



Start Date: 3/28/2011

Required Date: 4/1/2011

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-133

Manufactured

No

100

Each

4.0000

1

3



Clevis



11.04.05

Location

Loc Qty

Loc Code

ST446A

4

45001

4

3

240-107

Purchased

No

100

Each

85.0000

1

3



SPRING SLOTTED PIN



11.04.05

Location

Loc Qty

Loc Code

ST400

85

115827

85

3

CR3213-4-2

Purchased

No

100

Each

107.0000

1

3



Cherry Rivet



11.04.05

Location

Loc Qty

Loc Code

ST312

107

113288

100

113368

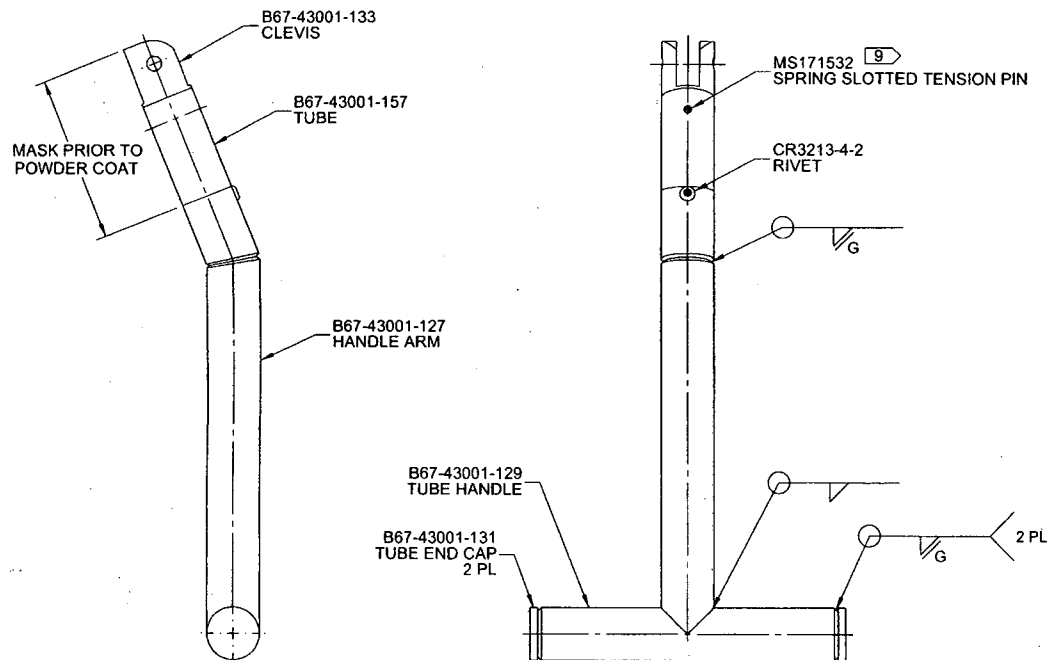
7

3

Monday, March 28, 2011 2:53:54 PM

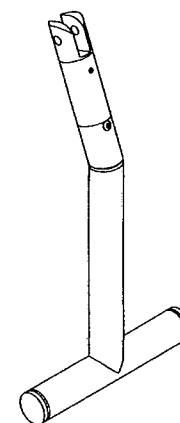
Shop Packet Print

Page 2



B67-43001-63 SHORT T-HANDLE ASSEMBLY

ITEM	QTY -63	P/N	DESCRIPTION
1	X	B67-43001-63	SHORT T-HANDLE ASSEMBLY
3	1	B67-43001-129	TUBE HANDLE
4	1	B67-43001-127	HANDLE ARM
5	1	B67-43001-157	TUBE
6	2	B67-43001-131	TUBE END CAP
7	1	B67-43001-133	CLEVIS
9	1	MS171532	SPRING SLOTTED TENSION PIN (OR 240107)
10	1	CR3213-4-2	RIVET



RELEASED
2010-09-16
MP

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDING" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.46 lbs
- 8) WELDING: PER DART QSI 004
- 9) ALIGN B67-43001-133 AS SHOWN. ENLARGE PILOT HOLE LOCATED ON HANDLE AND DRILL THRU B67-43001-157/133. DRIVE MS171532 IN TO HOLE.

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 15 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.06.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN			
CHECKED	RJS		
MFG. APPR.			
APPROVED	MP		
DE APPR.	N/A		
DATE	09.06.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-63** REV. C
TITLE **SHORT T-HANDLE ASSEMBLY** SCALE NTS

COPYRIGHT © 1995 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.